

Work Order ID 156654***156654***

Page 1

Monday, February 06, 2017 8:45:57 AM

Item ID: D4634-145 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft, Center Ceiling Replacement Panel Assembly
Start Date: 2/6/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/17/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 9-89 Date: FEB 06 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	G								DAS 07 9-89
100		0.00							
100									
HandThermo	Memo	0.14							
Hand Finishing Thermoforming	Pick Kit								17/03/06
110		0.00							DAS 07 9-89
110									
Small Fab	Memo	0.22							
Small Fab	Assemble as per Dwg D4634-145								17/03/09

1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe

2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.

Batch # 137023

Expiry Date 17/MAY29

3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By Lead hand / Supervisor Approval Verification		
					QC / QA Coordinator Approval				

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Work Order ID 156654

Monday, February 06, 2017 8:45:57 AM

156654

Page 2

Item ID: D4634-145

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 2/6/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/17/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

125

QC5- Inspect part completeness to step on W/O

0.00

125

QC

Memo

0.00

Quality Control

17-03-16

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

DAS
07
9-89

17/03/16

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.02

Quality Control

MAR 16 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Monday, February 06, 2017 8:46:01 AM

Page 1

Work Order ID: 156654

156654

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 2/6/2017

Required Date: 2/17/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09
Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23
DL IPP REV E Dwg update 14/01/09
DL IPP Rev F Dwg. update 14/02/03
DL IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4636-5		Manufactured	No			100	Each	45.0000	1	1			DAS 07 9-89

D4636-5

Bracket

Location	Loc Qty	Loc Code
ST115	45	
149102	1	
154779	20	
154916	24	

D4712-1

Manufactured No

100

Each

10.0000

1

1

DAS
07
9-89

D4712-1

Bracket

Location	Loc Qty	Loc Code
MF004	10	
149103	10	

D5021-5

Manufactured No

100

Each

1.0000

1

1

DAS
07
9-89

D5021-5

Foam, Center Panel, Aft

Location	Loc Qty	Loc Code
ST479a	1	
123923	1	

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

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Page 2

Work Order ID: 156654

156654

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 2/6/2017

Required Date: 2/17/2017

Start Qty: 1.00

Required Qty: 1.00

MS20426AD3-4

Purchased

No

100

Each

8,784.000

4

4

MS20426AD3-4

RIVET

DAS
07
9-89

17/03/07

Location

Loc Qty

Loc Code

GA

4821

m136444

4821

ST312

3963

m134294

3963

4

MS20426AD4-6

Purchased

No

100

Each

2,393.000

2

2

MS20426AD4-6

Rivet

DAS
07
9-89

17/03/07

Location

Loc Qty

Loc Code

GA

1894

M134502

25

M136537

1869

ST311

499

M134502

499

2

MS21059L08

Purchased

No

100

Each

186.0000

2

2

MS21059L08

Nut

DAS
07
9-89

17/03/07

Location

Loc Qty

Loc Code

ST300

186

m134943

86

m136554

100

2

D4634-5

Manufactured

No

100

Each

0.0000

1

1

D4634-5

Aft, Center Ceiling Panel

DAS
07
9-89

17/03/07

w/o. 156653.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 3

Work Order ID: 156654

156654

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 2/6/2017

Required Date: 2/17/2017

Start Qty: 1.00

Required Qty: 1.00

D4647-1

Manufactured No

100

Each

11.0000

1

1

D4647-1

Doubler

DAS
07
9-89

17/03/07

Location

Loc Qty

Loc Code

MF004

9

129251

1

155284

8

ST116

2

154781

2

D4664-5

Manufactured No

100

Each

45.0000

6

6

D4664-5

Spacer

DAS
07
9-89

17/03/07

Location

Loc Qty

Loc Code

MF004

45

154825

45

D4732-17

Manufactured No

100

Each

2.0000

1

1

D4732-17

Label

DAS
07
9-89

17/03/07

Location

Loc Qty

Loc Code

MF005

2

149138

2

D4732-23

Manufactured No

100

Each

8.0000

1

1

D4732-23

Label

DAS
07
9-89

17/03/07

Location

Loc Qty

Loc Code

MF005

8

123211

8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, February 06, 2017 8:46:02 AM

Page 4

Work Order ID: 156654

156654

Parent Item: D4634-145

D4634-145

Parent Item Name: Aft, Center Ceiling Replacement Panel Assembly

Start Date: 2/6/2017

Required Date: 2/17/2017

Start Qty: 1.00

Required Qty: 1.00

D4732-27

Manufactured No

100

Each

8.0000

1

1

D4732-27

Label

123213

**

DAS
07
9-89

17/03/07

Location

Loc Qty

Loc Code

MF005

8

123213

8

MPNY-750S-9-C

Purchased

No

100

Each

695.0000

9

9

MPNY-750S-9-C

Mounting Pad

**

DAS
07
9-89

17/03/07

Location

Loc Qty

Loc Code

ST569

695

M130423

695

9

Monday, February 06, 2017 8:46:02 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

ITEM	QTY	P/N	DESCRIPTION
1	X	D4634-145	AFT, CENTER CEILING REPLACEMENT PANEL ASSY
2	1	D4634-5	AFT, CENTER CEILING PANEL
3	1	D4636-5	BRACKET
4	1	D4647-1	DOUBLER
5	6	D4664-5	SPACER
6	1	D4712-1	BRACKET
7	1	D4732-17	LABEL
8	1	D4732-23	LABEL
9	1	D4732-27	LABEL
10	1	D5021-5	FOAM, CENTER PANEL, AFT
11	9	MPNY-750S-9-C	MOUNTING PAD
12	4	MS20426AD3-(4)	RIVET, SOLID, CSK
13	2	MS20426AD4-(6)	RIVET, SOLID, CSK
14	2	MS21059L08	NUT PLATE

D4634-145 AFT, CENTER CEILING REPLACEMENT PANEL ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4647-1 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE.
- 9) LOCATE D4647-1 IN LINE WITH RECTANGULAR OPENING
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5021-5 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5021-5 FOAM ON D4634-5

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
156654
MJS
1702-06

APPROVED

DESIGN	RF
DRAWN	RF
CHECKED	AK
MFG. APPR.	DL
APPROVED	HS
DE APPR.	DS
DATE	14.11.28

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4634	REV. G
TITLE CENTER CEILING PANELS	SCALE NTS
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2015 JAN 26